

Work Order ID 50489



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July 10, 2009 2:39:47 PM

Item ID: D3844-2KIV
Revision ID: A-PROTO
Item Name: Overhead Panel, RH

Accept



Setup Start



Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3844

A-PROTO

09.06.18

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/13 X1
M 109703

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA049 using tool DT9290-B
Dwg Rev: A
Folio Rev: A

BB 09/07/13 X1

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Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Stop

**Insp.
Stamp**

0.00

QC

Memo

0.00

Visually inspect part for proper formation and texture

BB 09/07/16 ~~xt~~

0.00

QC

Memo

0.00

Wk 08/07/14 (X)

0.00

HandThermo

Memo

0.00

1-Trim to finished dimensions as per Dwg

DL 09/07/14 (41)

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Stop

**Cust Item ID:**

11

Customer:

Reference:

[illegible]

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Operation Description

Set Up/ Run Hours

Draw Number	Draw Rev.	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

150

QC2- Inspect parts off machine FAI/FAIB

0.00

RESEARCH

QC

Memo

0.00

Quality Control

Complete FAI document

160

QC5- Inspect part completeness to step on W/O

0.00

[illegible]

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

Work Order ID 50489

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Item ID: D3844-2KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Overhead Panel, RH

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09.07.20 Prototype

23-07-09

Picklist Print

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July 10, 2009 2:39:46 PM

Work Order ID: 50489

Parent Item: D3844-2KIVRevA-PROTO

Parent Item Name: Overhead Panel, RH

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	5.8819			



6185 KYDEX .080"



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

894.5037653

109703

894.503765

BB 09/07/13
M109703 (X1)

DART AEROSPACE LTD	Work Order: 50489
Description:	Part Number: 03844-2K14
Inspection Dwg: 03844-2 Rev: A PHOTO	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

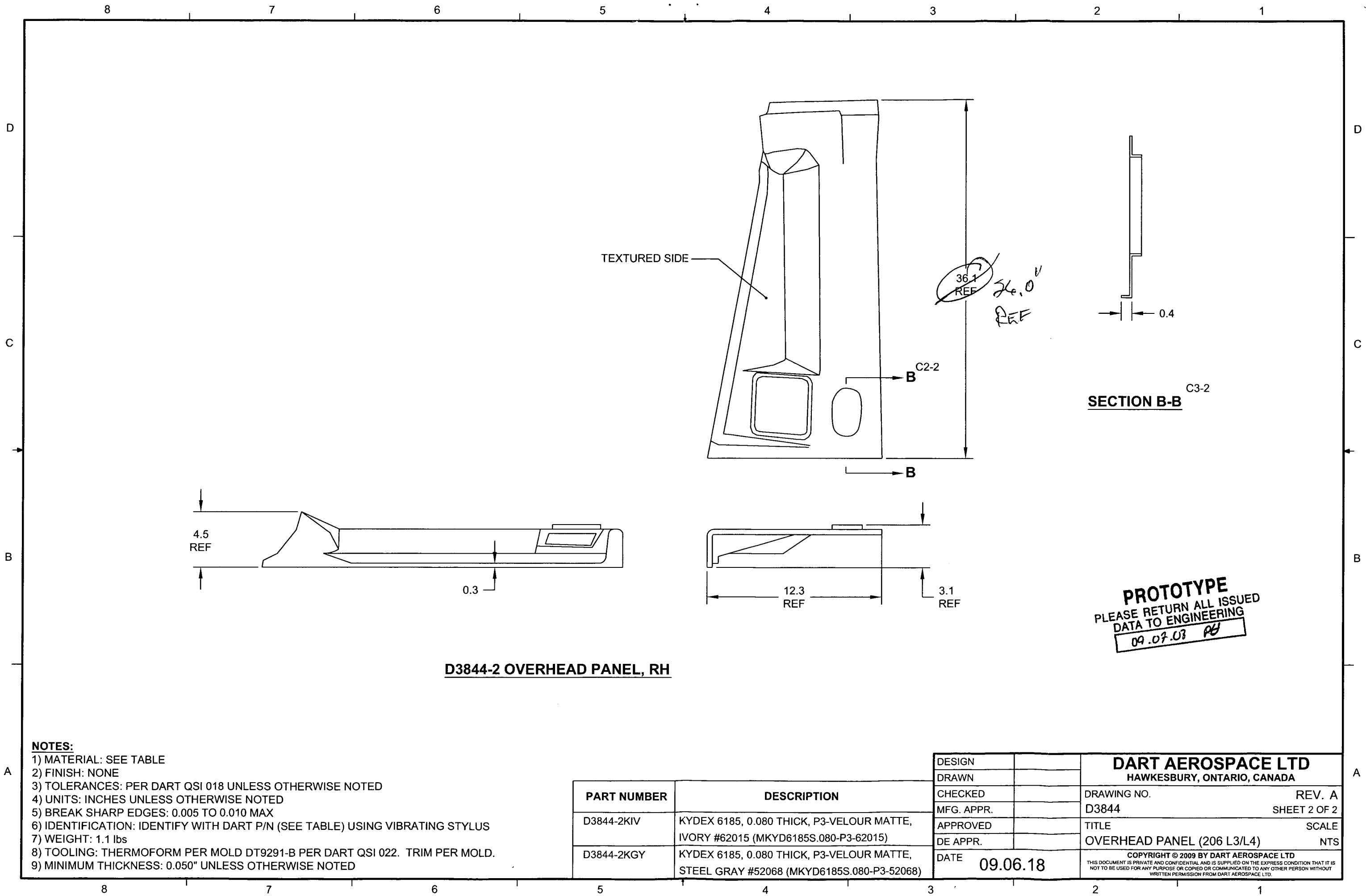
Measured by:	Date:
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.4	$\pm .100$.5"	✓			
25.5 26.0 "	Ref	25.5 26.0 "	✓			
3.1"	$\pm .100$	3.1 3.4 "	✓			
12.3"	Ref	12.5"	✓			
0.30"	$\pm .100$	0.40	✓			
0.045 0.050	MIN	0.060	✓			
0.045 0.050	↓	0.060	✓			
0.030 0.030 0.05	↓	0.033	✓			

Measured by: D. Lopez	Date: 09/02/14
Audited by: RB	Date: 09-07-17
Prototype Approval: RB	Date: 09-07-17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

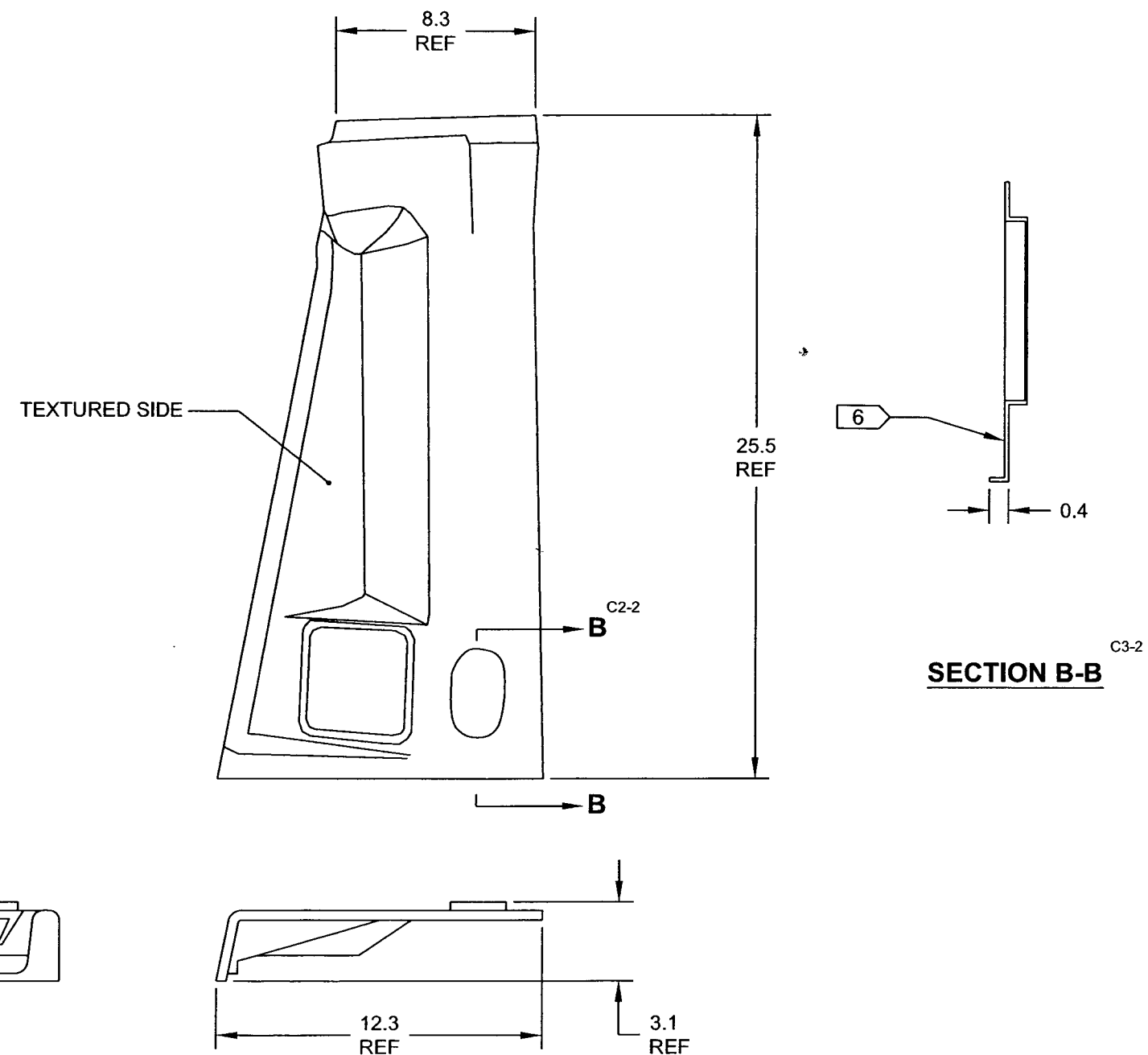


D

C

B

A



D3844-2 OVERHEAD PANEL, RH

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9291-B PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.045" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3844-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3844-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	PA	
CHECKED	PA	DRAWING NO. REV. A
MFG. APPR.	PA	D3844 SHEET 2 OF 2
APPROVED	PA	TITLE SCALE
DE APPR.	PA	OVERHEAD PANEL (206 L3/L4) NTS
DATE	09.06.18	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.